

Date:
User:Tuesday, 11/13/2007 1:24:08 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL ASSEMBLY
 Job Number : 35649 *2*
 Estimate Number : 13008
 P.O. Number : *N/A* Part Number : D3245041
 This Issue : 11/13/2007 S.O. No. : *N/A* Drawing Number : D3245 REVB
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 34551 Material : *N/A* Due Date : 11/28/2007 Qty: *6* Um: *12* Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev: A New Issue 07-09-11 JLM Verified By: EC
 Est Rev: b ECN 1052 07-10-31 DD verified by: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D32451	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Panel
 Batch: *B 35656*

3.0	D32455	Angle Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Angle Plate
 Batch: *B 35047 x 6* *B 35667 x 6* *AS 9/12/19*

4.0	235018C3Y	RIGID RECEPTACLE
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)
 RIGID RECEPTACLE
 Batch: *M 106037* *AS 9/12/19*

5.0	MS20427M33	Rivet
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)
 Rivet
 Batch: *M 105940 x 20* *AS 9/12/19*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 35649

Part Number: D3245041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 MS20615M33 Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total : 54.0000 Each(s)

Rivet

106277

NOT in Computer

M18235x54



AS 07/12/19

(46)

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245

MF 07-12-19

(5)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 07/12/20 (46)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with part# and batch# using fine point ink marker and Stock

Location: ST183

AS 02/12/20

(46)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

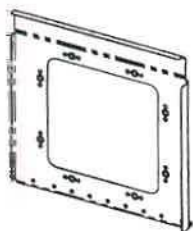
D 08/12/21

Completion



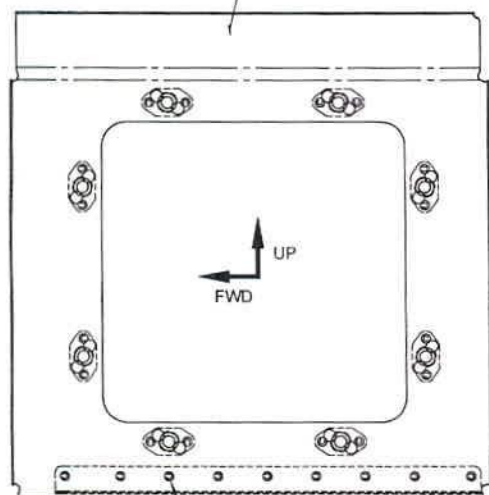
2007/12/21

W



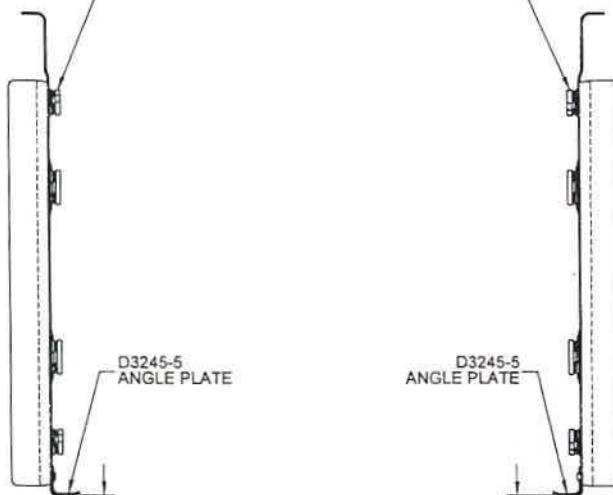
D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



MS20615M3-3 RIVET
(9 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

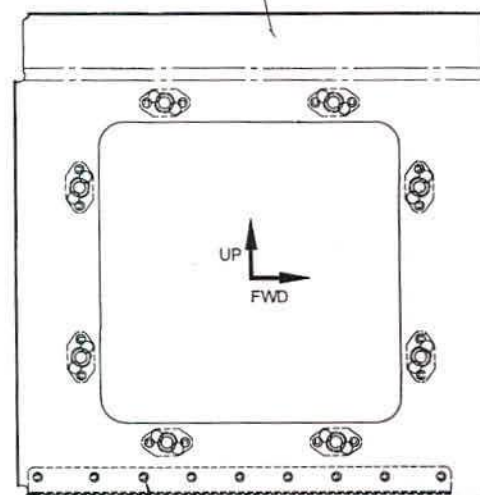
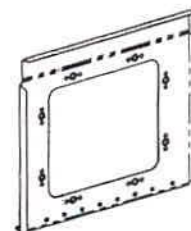


D3245-5
ANGLE PLATE

0.032
GAP

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL



MS20615M3-3 RIVET
(9 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

B		REMOVE Ø0.204 HOLES FROM D3245-1-1F. REMOVE MS21060-LJK NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING		MB	07.10.02
A		NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION			BY	DATE
DESIGN	DART AEROSPACE LTD			REV. B	
DRAWN	HAWKESBURY, ONTARIO, CANADA			SHEET 1 OF 7	
CHECKED	DRAWING NO. D3245			SCALE 1:2.5	
MFG. APPR.	TITLE ACCESS PANEL ASSEMBLY				
APPROVED	DATE 07.10.02				
DE APPR.	COPYRIGHT © 2004 BY DART AEROSPACE LTD				
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WORK ORDER
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